

Work Order ID 84600

May-16-12 4:14:23 PM

84600

Page 1

Item ID: D044-713-014

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bubble Window, RH

Start Date: 16/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 30/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/05/16

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9329	B
IIN D044-713	A

100 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefiles and create labels per PPP D044-713-014 & DSI 9329
CHG003

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

ML5 12-5-17

(2)

(24) 12/5/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84600

84600

Page 2

May-16-12 4:14:23 PM

Item ID: D044-713-014 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Bubble Window, RH
Start Date: 16/05/2012 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 30/05/2012 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120		0.00							
QC	Memo								
Quality Control									
130	Packaging	0.00							
130		0.00							
Packaging	Memo								
Packaging	Identify and pack for shipping as per PPP D044-713-014								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140		0.00							
QC	Memo								
Quality Control									

MF
12-05-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84600

84600

Parent Item: D044-713-014

D044-713-014

Parent Item Name: Bubble Window, RH

Start Date: 16/05/2012

Required Date: 30/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A05.03.22New issueKJ/JLM
IPP Rev:A06-07-03As per DSI 9329 JLM
IPP Rev:C 08-07-30 chg qty DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

DT8720		Manufactured	No			110	Each	0.0000	1	2			
--------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

DT8720

template									**				
----------	--	--	--	--	--	--	--	--	----	--	--	--	--

D2126		Manufactured	No			110	f	332.1803	7.525	15.84211			
-------	--	--------------	----	--	--	-----	---	----------	-------	----------	--	--	--

D2126

Seal									**				
------	--	--	--	--	--	--	--	--	----	--	--	--	--

Location

Loc Qty

Loc Code

ST405

332.18029

57106

4

68336

2.44679

76094

325.7335

(D2126-0903) cut 1 at 90.30"

D3269-2		Manufactured	No			110	Each	0.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3269-2

Bubble Window, RH

D3312-1		Manufactured	No			110	Each	6.0000	1	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3312-1

Placard									**				
---------	--	--	--	--	--	--	--	--	----	--	--	--	--

Location

Loc Qty

Loc Code

ST038

6

82809

6

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>qp</i>	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9329	REV. B SHEET 1 OF 1
DATE 06.06.26		TITLE BUBBLE WINDOW INSTALL MOD.	SCALE NTS
A	06.04.25	NEW ISSUE	
B	06.06.26	CHG TO EFFECTIVE AFTER CHG 002	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-713 REV. A

REF. CANADIAN STC: SH05-13 ISSUE 1

REF. FAA STC: SR02088NY

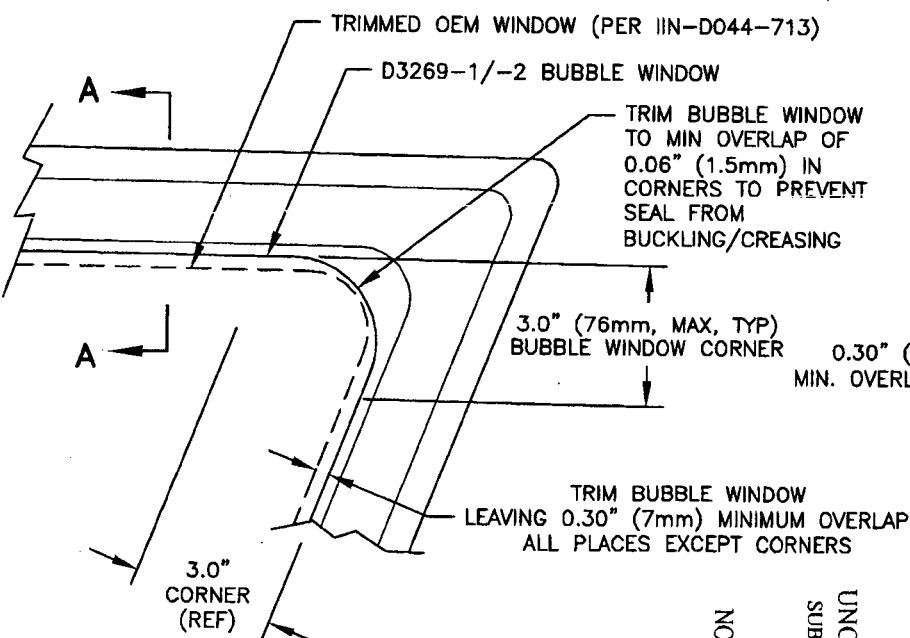
PURPOSE: For the D044-713-013/-014 kits supplied after CHG 002, the D3267-1/-2 bubble windows have been supplied untrimmed to allow for easier installation in the field. The installer must trim the windows in accordance with these instructions prior to installation.

PROCEDURE:

- 1) Modify the R44 crew door per items 3.2.1 and 3.2.2 of Installation Instructions IIN-D044-713 Rev.A.
- 2) Fit and trim the D3269-1/-2 Bubble Window to match the cutout in the door as follows: The bubble window must be a minimum of 0.30" (7mm) larger than the cutout in the OEM window as shown in the figure below. However, in the corners of the window, it is acceptable to trim a 0.06" minimum overlap (1.5mm) to help prevent the D2126-0903 Seal from buckling/creasing in the corners. The edge of the bubble window must be deburred to a smooth finish.
- 3) Continue installing the bubble window per items 3.2.3 through 3.2.5 of the installation instructions.

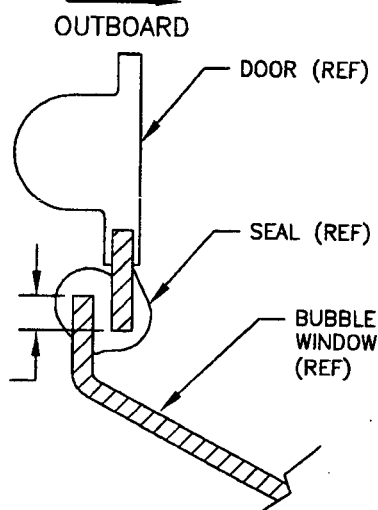
FIGURE 1

LOOKING AT INSIDE CORNER OF DOOR



SECTION A-A

(NOT TO SCALE)



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.06.26
CERT. NO.: SH05-13
ISSUE NO.: 1

SHOP COPY
RETURN TO
ENGINEERING
WITHOUT NOTICE
WORK ORDER
NO. 24600
MC
12/05/16

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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of Section A	NC	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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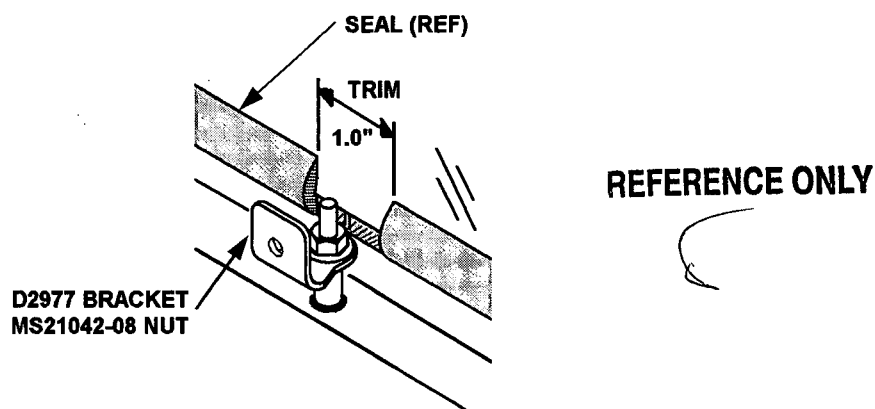


FIGURE 4 – D044-713-015 Passenger Door Window Kit – Tab Installation

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-713-011 Crew Door Window Kit	1.5 lb 0.68 kg	±24 in ±0.61 m	±36 in-lb ±0.43 m-kg	66 in 1.68 m	99 in-lb 1.1 m-kg
D044-713-013 Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-014 Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-kg	66 in 1.68 m	165 in-lb 1.8 m-kg
D044-713-015 Passenger Door Window Kit	1.2 lb 0.54 kg	±23 in ±0.58 m	±28 in-lb ±0.31 m-kg	83 in 2.11 m	100 in-lb 1.1 m-kg

5.0 PARTS LIST

Qty -011	Qty -013	Qty/ -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	1		D2126-0903	SEAL
	1			D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

* Not to be installed. Cutting template only.

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Revision: **A**
Date: 05.01.10